

Work Order ID 48635A

Friday, June 26, 2009 11:51:05 AM

Page 1

Item ID: D3821-3KGY

Accept

Setup Start

Revision ID: B

Stop

Item Name: Panel w/ Rotor Brake-Grey

Start Date: 7/15/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

100

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Machine Set-Up

BB 09/07/01

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Cut Sheet to required Blank size

MK1/06185 080P
Grey

M III 807

BB 09/07/01 (X2)

120

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg and Folio #FTA024 using tool DT9054

Dwg Rev: B

Folio Rev: A


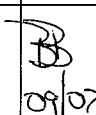
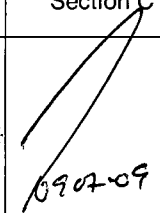
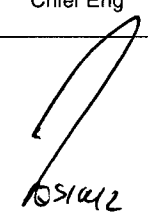

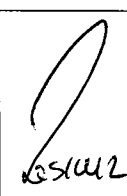
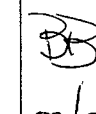
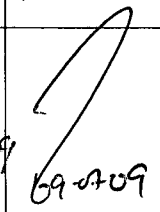

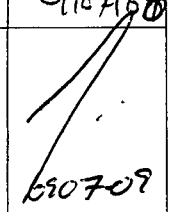
BB 09/07/01 (X2)

1 Scrap - PTD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3821-3 KGY PAR #: N/A Fault Category: Thermo NCR: Yes No DQA: 1 Date: 09-07-10
Resolution: Scrap Disposition: Scrap QA: N/C Closed: 1 Date: 05-08-17

NCR: <u>48635A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/7/01	110	During Forming a chip was in the mold. And Deformed the Part.		Scrap and Destroy and Replace m# 111807	 09/07/08	 09-07-09		 09/07/08
		Re: Tiny crack on a sharp corner in the center, retesting during forming.		Re-prior the chip in the mould	 09/07/09	 09-07-09		 09-07-09

NOTE: Date & initial all entries

Work Order ID 48635A

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Page 2

Item ID: D3821-3KGY

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Required Date: 8/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

BB 09/07/07

(X1)

Quality Control

(X1) SCRAP

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Ph 09/07/07

(X1)

Quality Control

150

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Trim to finished dimensions as per Dwg

BB 09/07/08 (X1)

Work Order ID 48635A

Friday, June 26, 2009 11:51:05 AM



Page 3

Item ID: D3821-3KGY

Accept



Setup Start



Revision ID: B

Stop



Item Name: Panel w/ Rotor Brake-Grey

Start Date: 7/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

BB 09/07/08 (X1)

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 80267/08 Q

180

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

9/7/9 (XV) SP

Work Order ID 48635A

Friday, June 26, 2009 11:51:05 AM



Page 4

Item ID: D3821-3KGY

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Item Name: Panel w/ Rotor Brake-Grey

Start Date: 7/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/09

h 9/07/09

Picklist Print

Page 1

Friday, June 26, 2009 11:51:04 AM

Work Order ID: 48635A



Parent Item: D3821-3KGYRevB



Parent Item Name: Panel w/ Rotor Brake-Grey

Start Date: 7/15/2009

Required Date: 8/3/2009

Comments: Est Rev:A New Issue 09-06-02 DL

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ MKYD6185S.080-P3- 52068		Purchased	No			100	sf	0.0000	12.7968			



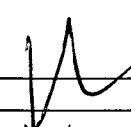
Kydex steel grey



BB 09/07/08.
M111807

Date: Thursday, 18/06/2009 10:00:23 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PANEL-W/ROTORBRAKE, GREY
Job Number : 48635A	
Estimate Number : 13963	
P.O. Number :	Part Number : D38213KGY
This Issue : 18/06/2009 S.O. No. :	Drawing Number : D38213
Prsht Rev. : NC	Project Number :
First Issue : / / Type : THERMOFORMING	Drawing Revision : <i>BB</i>
Previous Run :	Material : MKYD6185S080P352068
Written By : 	Due Date : 24/06/2009 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est. Rev A New Issue 09/06/02 DL	

Additional Product

Job Number:

*no route.*

Seq. #:

Machine Or Operation:

Description :

1.0

MKYD6185S080P352068

6185 Kydex .080 steel grey



Comment: Qty.: 12.7969 sf(s)/Unit Total : 12.7969 sf(s)
 6185 Kydex .080" Grey

*M 111807**BB 09/07/01*

2.0

HAND FINISH TH

HAND FINISHING THERMOFORMING

**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/07/01

3.0

HAND FINISH TH

HAND FINISHING THERMOFORMING

**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/07/01 X2

4.0

THERMOFORMING

THERMOFORMING MACHINE

**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3821-3 and folio FTA 024 using tool DT 9054

*1 SCRAP*Dwg. Rev. *B*Folio Rev. *A**BB 09/07/01 X2*

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/07/01 X1

Date: Thursday, 18/06/2009 10:00:23 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-W/ROTORBRAKE, GREY

Job Number: 48635A

Part Number: D38213KGY

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

DL 09/07/08 (X1)

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BR 09/07/08 (X1)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BR 09/07/08 (X1)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



DART AEROSPACE LTD		Work Order: 48635A
Description:		Part Number: D3821-3 K4Y
Inspection Dwg: 3821	Rev: 3	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: [Signature]

Date: 09/07/08

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	M.I.N	1.1	✓			
.75	M.I.N	.751	✓			
.25	M.I.N	.375	✓			
.63	M.I.N	.70	✓			
.375	M.I.N	.378	✓			

Measured by: [Signature]

Date: 09/02/08

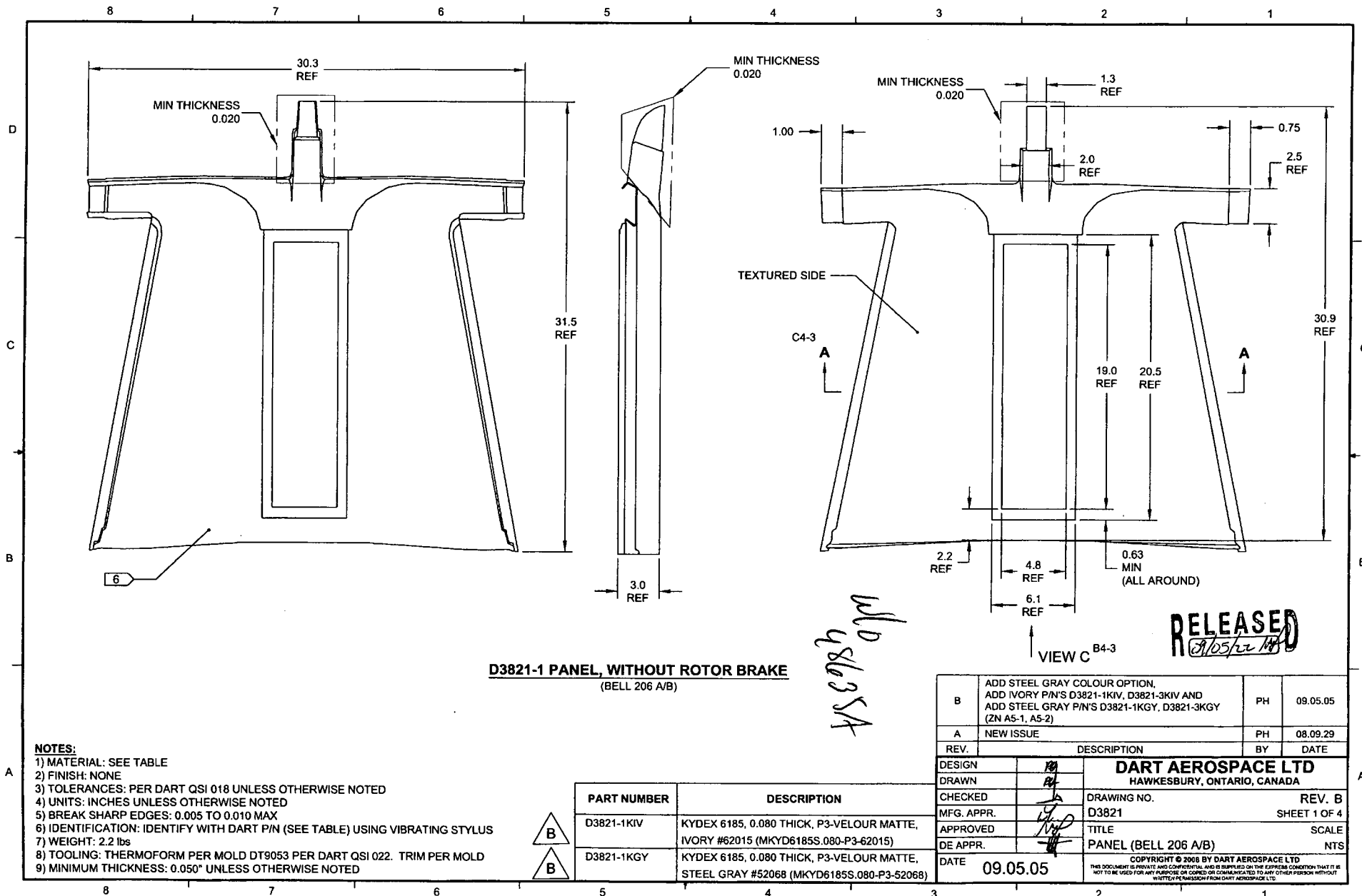
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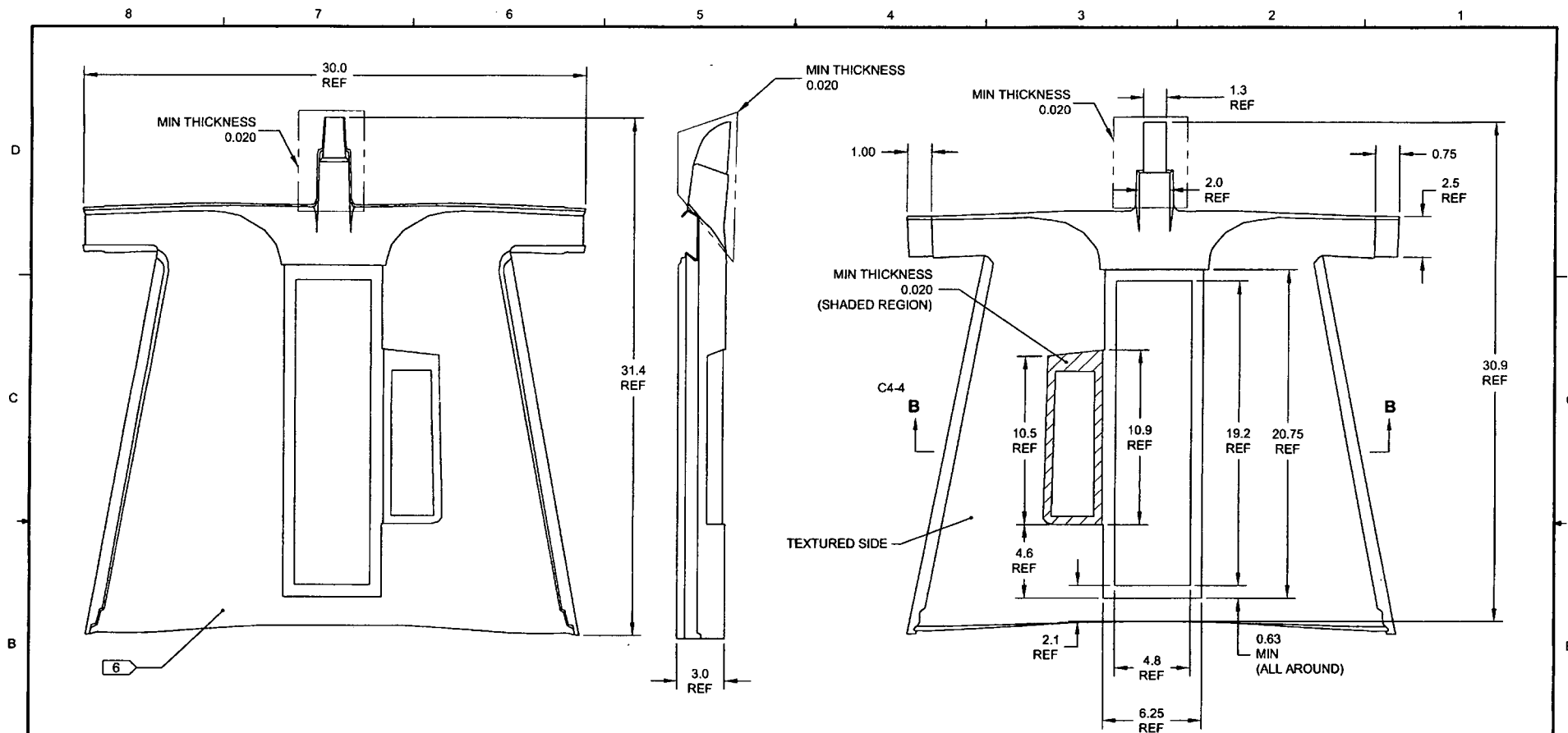
Date: 09/07/08

Prototype Approval: [Signature]

Date: 09/07/08

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	





D3821-3 PANEL, WITH ROTOR BRAKE
(BELL 206 A/B)

VIEW D B4-4

RELEASED
09/05/05

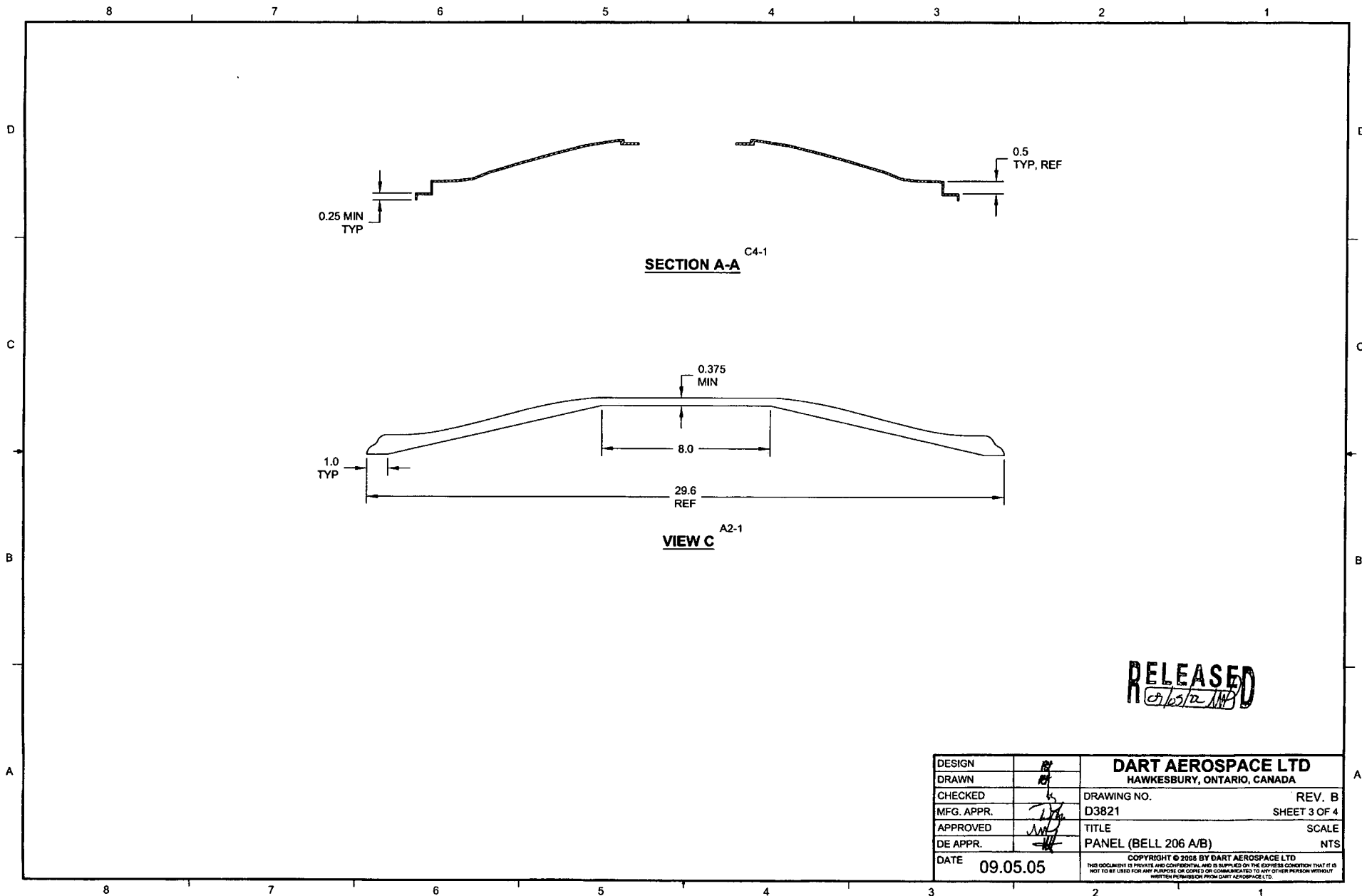
NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 2.2 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9054 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED



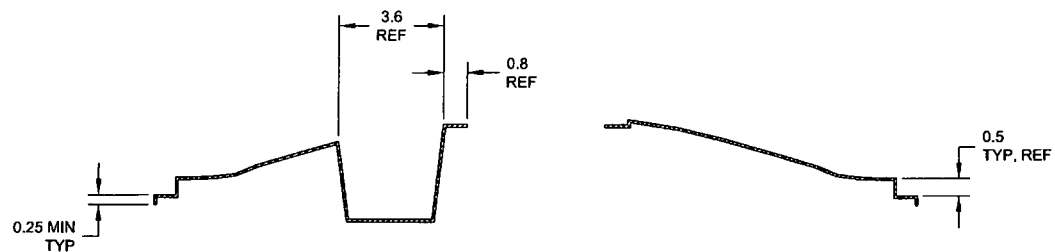
PART NUMBER	DESCRIPTION
D3821-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3821-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D3821 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		PANEL (BELL 206 A/B) NTS
DATE	09.05.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD
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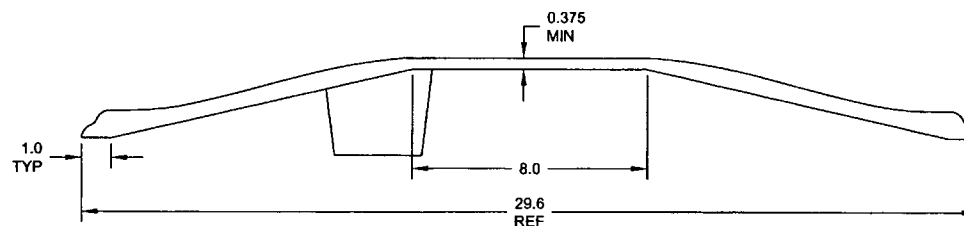


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CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3821	SHEET 3 OF 4
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SECTION B-B C4-2



VIEW D C4-2

RELEASED
09/05/22 JH

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